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Hawkesbury, ON
K6A 1K7
Canada

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D350-636-016
Job Sheet 202707



Part No: D350-636-016 **Job Qty:** 1 pcs
Part Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 11/1/19 **Job Tracking No:**
Due Date: 11/29/19 **Created By:** Jennifer Renwick
Type: Stock **Description:** SIOP
Note: DWG D4168-042 REV.C IPP rev:A 10.09.28 new issue DD ver:EC IPP Rev:B 11.04.14 ecn11-553 DD ver:EC IPP Rev:C 11.10.18 as per NCR 11-906 DD ver:EC IPP REV:D 13.08.28 PER ECN13-594 DD VERF:JLM IPP REV:E 18.11.12 AS PER DWG REV.C DD VERF:JFS
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	11/29/19		0.00	4.50	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		BE
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 10	1 pcs	11/29/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
							QC 10 - 68		DAS NOV 19 2019 68
130	QC 5	1 pcs	11/29/19		0.00	0.00	QC 5 - 10		9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		DAS NOV 19 2019 68
							QC 5 - 9		9-89
							QC 5 - 50		

140 Handfinish - 1-1 Chemical-B4B	1 pcs	11/29/19	0.00 0.98	QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	BEB 19-11-22
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
150 QC 7	1 pcs	11/29/19	0.00 0.00	Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	MO-6
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	

					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
160 Skidtubes - 2 - B4B	1 pcs	11/29/19	0.00 7.00		Skidtubes - 1 - B4B	DD
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	TF
					Skidtubes - 5 - B4B	BR
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
170 QC 10	1 pcs	11/29/19	0.00 0.00		QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
					QC 10 - 68	DAS
					QC 5 - 10	DEC 0 9 2019 68
					QC 5 - 12	9-89
180 QC 5	1 pcs	11/29/19	0.00 0.00		QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	DAS
					QC 5 - 68	DEC 0 9 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190 Handfinish - 2-1 Pressure-B4B	1 pcs	11/29/19	0.00 0.33		Handfinish - 2 - 1 - B4B	DEC 0 9 2019
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	DAS
200 Spray Paint - 2 - B4B	1 pcs	11/29/19	0.00 0.61		Spray Paint - 1 - B4B	DEC 1 1 2019
					Spray Paint - 2 - B4B	9-89
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
210 QC 14	1 pcs	11/29/19	0.00 0.00		QC 14 - 15	14-12-16
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	

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15
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				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Handfinish - 4 - 1 - B4B	14-12-12
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	

220 Packaging 2-1 - Receive - B4B 1 pcs

11/29/19

0.00 0.00

Not required.

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230 Handfinish - 4-1-Assembly-B4B

1 pcs

11/29/19

0.00 0.98

240 QC 5	1 pcs	11/29/19	0.00 0.00	Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	11/29/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	

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260 QC 4	1 pcs	11/29/19	0.00 0.00	Packaging 1 - 36 - B4B	
				QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
270 Packaging 3-1 - Stock - B4B	1 pcs	11/29/19	0.00 0.00	QC 4 - 78	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	11/29/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
280 QC 21 - FG	1 pcs	11/29/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

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Part Op 110 - (Skidtubes) 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT
Descriptions: end per dwg D4168-2 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168 sheet 5 (D4168-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K) 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section R-R and open to 0.500" 5- Drill tow ring hole using DT9616 detail "J" 6- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) +.201" (total of one hole per side DT9616) as per

FG012

dwg D4168. 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004
 A/R Aluminum Rod batch: 139019 9- Grind welds flush as per Dwg D4168
 120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (Skid tubes) 1-Open up holes using hole saw of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168. 2-Open up holes using hole saw of Detail K to 0.750" (total of 4 holes per side) as per dwg D4168. 3- Open float hole to 0.500" using uni-bit (4 per side) and Run on wearplate holes to .375" 4 per side 4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168 (welding instructions on sheet 9) 5-Debur and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5231095 exp. date: 03/18/2020 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 139019 9- At section AP-AP drill out x-bolt spacer to 0.404" 10- Grind welds flush as per Dwg D4168 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168 12- C'bore section CH-CH. ADJUST TOOLING AS REQUIRED. VERF BY: _____ 13- Debur holes, ensure tube is free of all scratches before sending to paint. ***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE ***** REF TO W/O BATCH:
 170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
 190 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
 200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5211188 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5231053
 210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
 220 - Receive and inspect for damage + mat'l certs
 230 - (Assemble as per dwg) 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-4, wearshoes and ground handling hardware as per dwg D4168 SIKAFLEX 241 BATCH: 5231095 EXP DATE: 20-3-18 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: _____ 5-Coat all exposed fasteners with "LPS Procyon" batch: 1133690
 240 - (QC5- Inspect part completeness to step on W/O)
 250 - (Pick Kit) If making a D350-636-216 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1
 260 - (QC4- 100% Inspect kits for completeness) *****ensure antiseize is on AN8C21A bolts*****
 270 - Identify and pack for shipping as per PPPD350-636-016 Location : FG071
 275 - (Document Control) record fwd angle: 89.9° Photocopy blue file and type labels per PPP D350-636-016 CHG 006
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

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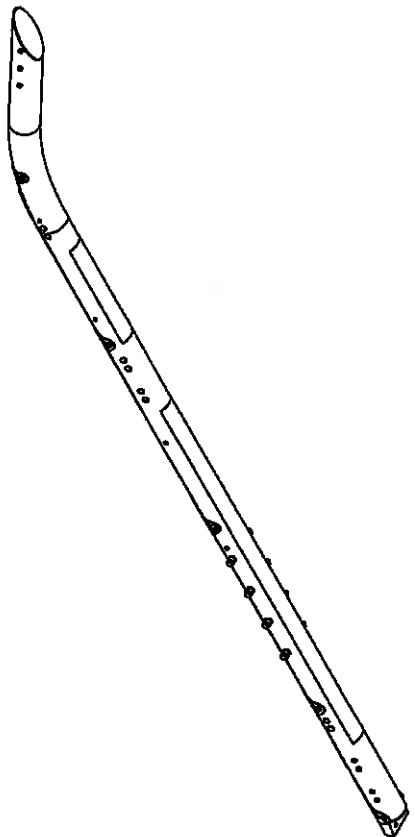
Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 pcs (1 ea)	110-Skidtubes - 1	5246212
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5172770
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B	5231540
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B	5214194
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5210529
D3490-3	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5226157
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5214460
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5186091
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	FM1138009-2
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5217722
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5230839
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5221549
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5233497
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5233497
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5202645
D3492-3	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5218600
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5215332
D3873-1	Bushing	7 pcs (7 ea)	230-Handfinish - 4-1-Assembly-B4B	5230804
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5230837
D4170-1	Bushing	4 pcs (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5175928
D4171-1	Bushing	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5210491
MS21043-3	Nut	5 Ea (5 ea)	230-Handfinish - 4-1-Assembly-B4B	5180790
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5099569
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5225375
NAS1149C0332R	Washer (AN960C10L)	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5215506
NAS1149C0363R	Washer (AN960C10)	9 Ea (9 ea)	230-Handfinish - 4-1-Assembly-B4B	5253308
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	6185100
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5046027
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5214971
NAS1611-013	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5217831
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5234919
AN3C42A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5201295
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5232714
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5212551
D3493-1	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5225633
MS21133C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5237859
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166718

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-RH	1	8	0
	D2744	1	17	0
160-Skidtubes - 2 - B4B	D2739	1	6	0
	D2743	8	241	0
	D3490-1	4	146	0
	D3490-3	4	21	0
230-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	4	1,020	0
	AN3C34A	1	26	0
	AN3C36A	4	193	0
	AN3C6A	4	82	0
	AN6C44A	4	68	0
	AN8C35A	1	32	0
	D2745	8	79	0
	D3488-4	1	14	0
	D3492-1	8	112	0
	D3492-3	8	43	0
	D3631-1	8	68	0
	D3873-1	7	62	0
	D4154-041	1	3	0
	D4170-1	4	109	0
	D4171-1	1	17	0
	MS21043-3	5	1,263	0
	MS21043-6	4	319	0
	MS21083C8	1	87	0
	NAS1149C0332R	4	4,440	0
	NAS1149C0363R	9	421	0
	NAS1149C0832R	1	239	0
	NAS1515H3L	4	143	0
	NAS1611-010	8	168	0
	NAS1611-013	8	70	0
250-Packaging 1-1 - Pick Kit - B4B	AN3C37A	1	92	0
	AN3C42A	1	67	0
	AN8C21A	2	47	0
	D2741	1	47	0
	D3493-1	2	51	0
	MS21083C8	2	87	0
	NAS1149D0863J	2	297	0

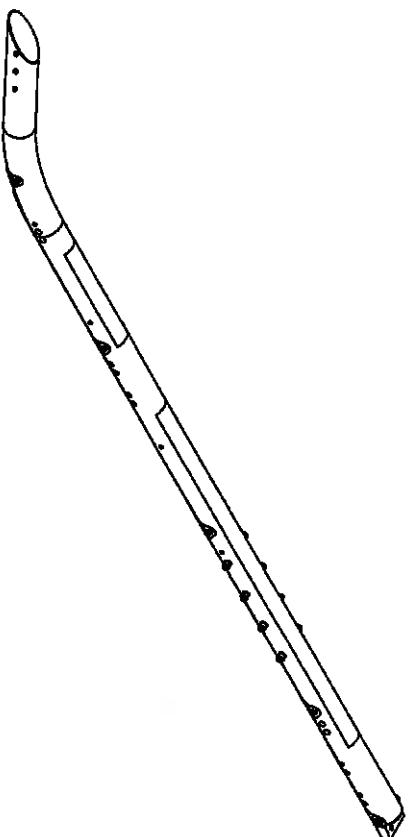
Part Specifications

Specifications could not be found.

Plex 11/1/19 9:20 AM Dart.Renwick.Jennifer



D4168-043 350 SKIDTUBE ASSEMBLY, LH



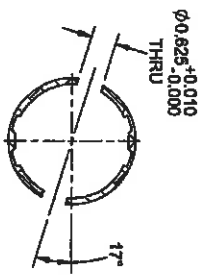
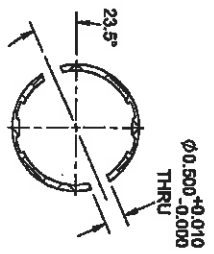
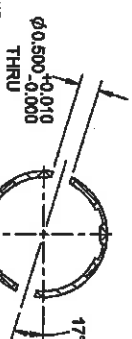
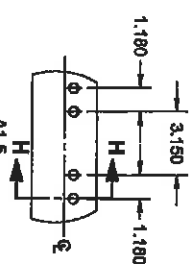
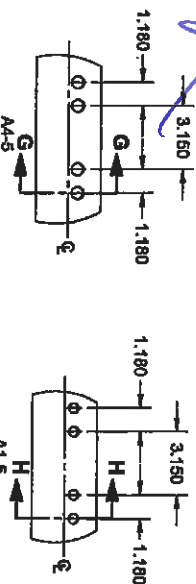
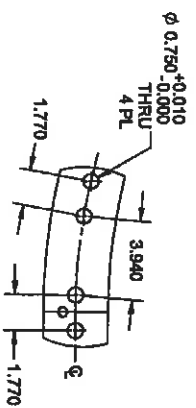
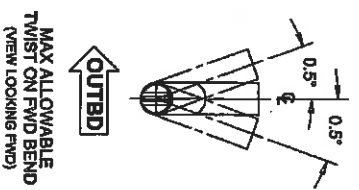
D4168-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2018 OCT 19

APPROVED

DESIGN	SC	DART AEROSPACE USA, INC.
DRAWN	ZF	EUGENE, OR
CHECKED	MM	
INFG. APPR.	DD	D4168
APPROVED	NO	TITLE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY
DATE	18.03.01	SCALE
		NTS

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**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)**

C7-5
DETAIL B
SCALE 2X

D5-5
DETAIL C
SCALE 2X

D3-5
DETAIL D
SCALE 2X

RELEASED
2010 OCT 19

B3
SECTION H-H
SCALE 4X, 4 PL

D6-5
SECTION E-E
SCALE 4X, 2 PL

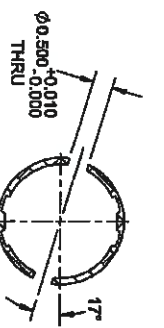
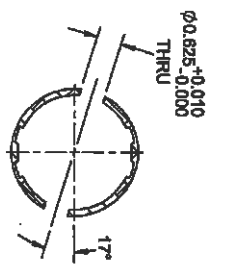
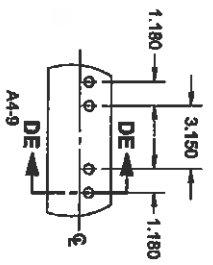
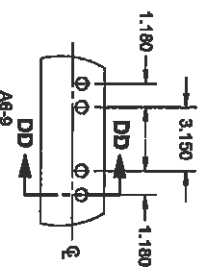
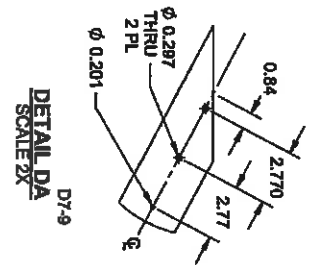
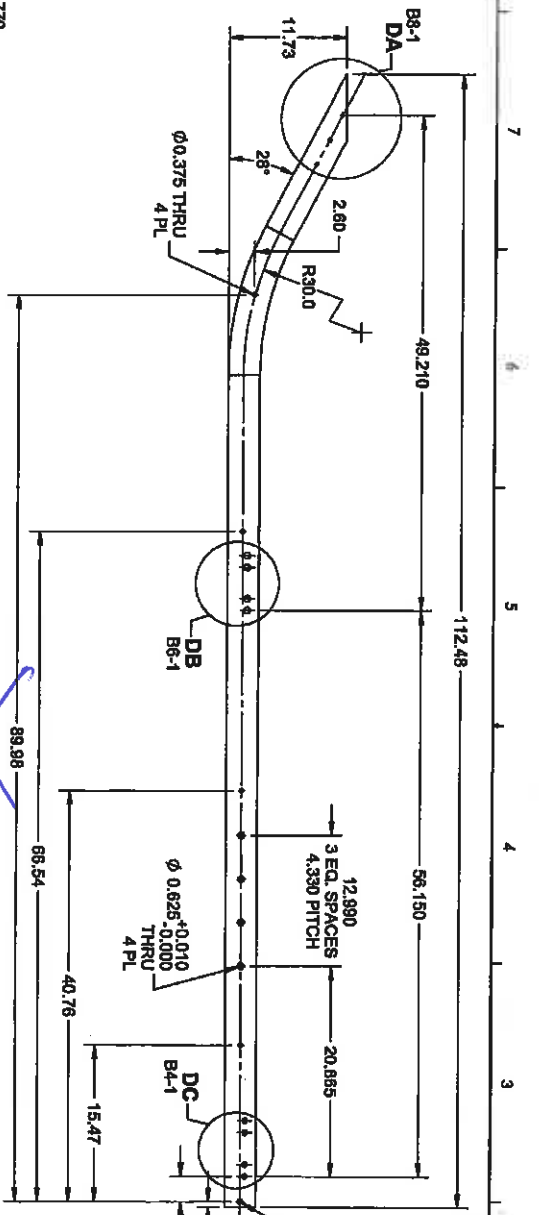
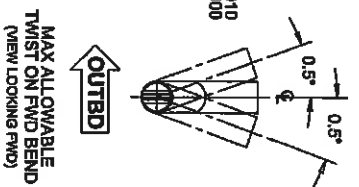
B4-5
SECTION G-G
SCALE 4X, 4 PL

APPROVED

DAI AEROSPACE USA, INC. ELIZABETH, OR		REV. C OF 46 SHEET 8 OF 46
DESIGN SC DRAWN ZF CHECKED MMV MFG. APPR. DD APPROVED NO DE APPR. DS	DRAFTING NO. D4168 TITLE 360 SKIDTUBE ASSEMBLY SCALE NTS	DATE 18.03.01

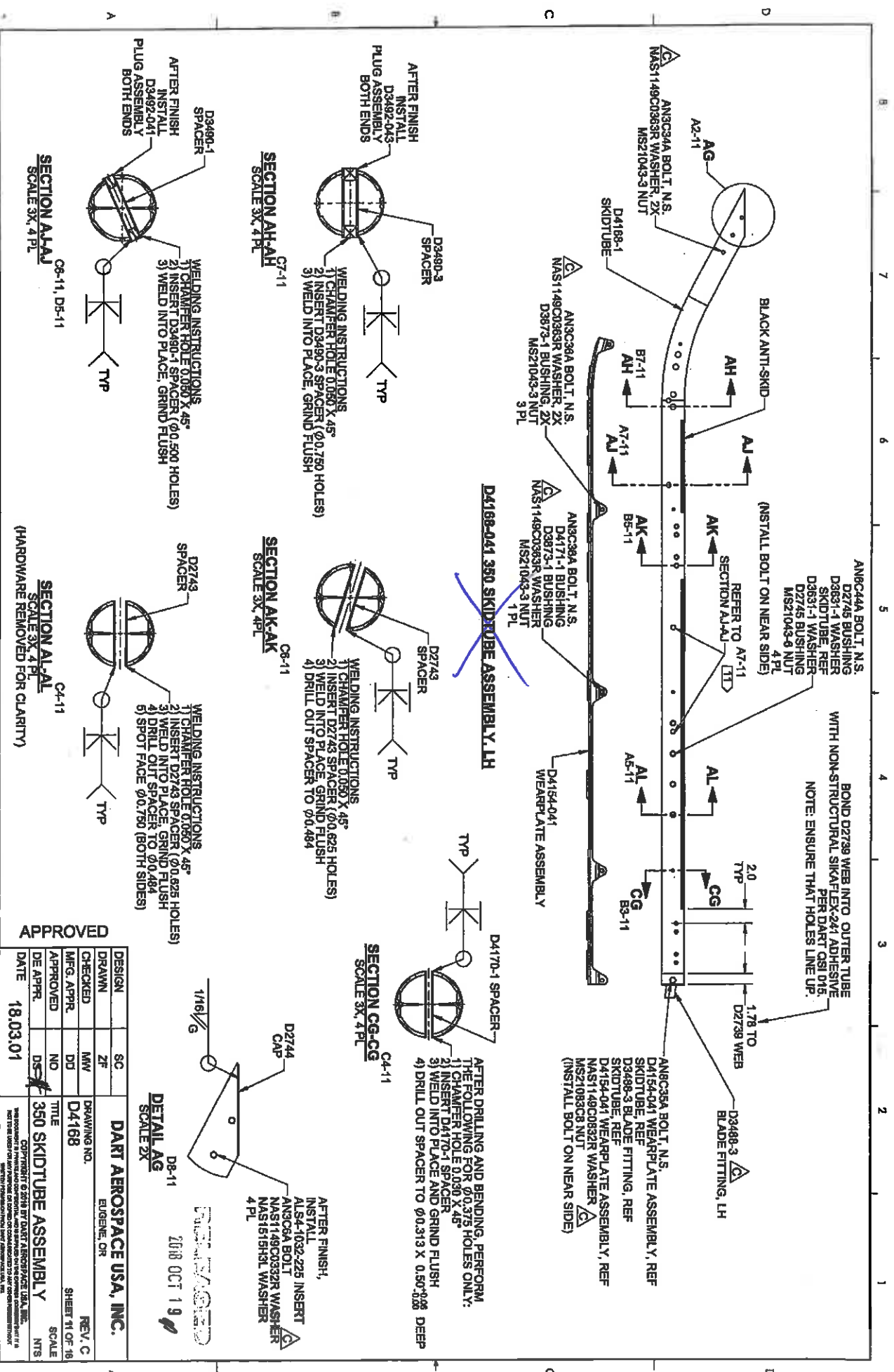
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RELEASED
2018 OCT 19

DESIGN		SC	DART AEROSPACE USA, INC.	
DRAWN		ZF	EUGENE, OR	
CHECKED		MMV	DRAWING NO.	
MFG. APPR.		DD	D4168	
APPROVED		NO	TITLE	
DE APPR.		DS	350 SKIDTUBE ASSEMBLY	
DATE		18.03.01	SHEET 8 OF 18	
			SCALE	
			NTS	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only ☐

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)			
Description Work Order Deviation		Disposition		Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Undeclared Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					

7.0 PARTS LIST
D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT
D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
	X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
		X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCUISEIR/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCUISEIR/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
						X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
							X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1							D4168-041	SKIDTUBE ASSEMBLY, LH
1		1						D4168-042	SKIDTUBE ASSEMBLY, RH
1			1					D4168-043	SKIDTUBE ASSEMBLY, LH
1				1				D4168-044	SKIDTUBE ASSEMBLY, RH
1					1			D4168-051	SKIDTUBE ASSEMBLY, LH
1						1		D4168-052	SKIDTUBE ASSEMBLY, RH
*1	1							D4168-1	SKIDTUBE WELDMENT, LH
*1		1						D4168-2	SKIDTUBE WELDMENT, RH
*1			1					D4168-3	SKIDTUBE WELDMENT, LH
*1				1				D4168-4	SKIDTUBE WELDMENT, RH
*1					1			D4168-5	SKIDTUBE WELDMENT, LH
*1						1		D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149CO832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
*8	1		1		1			D3488-3	BLADE FITTING, LH
*8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149CO863J	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149CO332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
*90	1	1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1			1	AN3C42A	BOLT ³
*92	7	7	7	7	7	7	8	NAS1149CO363R	WASHER
92A			1	1				NAS1149CO363R	WASHER ³
*93	4	4	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	7	7	8	D3873-1	BUSHING
94A			1	1				D3873-1	BUSHING ³
*95	1	1	1	1	1	1	1	D4171-1	BUSHING ⁴
96							4	D4170-3	SPACER
*97	1	1	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	2	2	NAS1149CO363R	WASHER
*99	1	1	1	1	1	1	1	MS21043-3	NUT

- * PART OF D4168-041/-042/-043/-044/-051/-052
- ** TO BE SUPPLIED BY CUSTOMER
- *** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH DART CYLINDRICAL OR TRI-BAG FLOATS
² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART CYLINDRICAL BAG FLOATS
³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS
⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

Change Record

PAGE 1 OF 1

Part Number: D350-636-015/-016

Description: SKIDTUBE STD LH/RH w/ TRAINING WEARPLATE

[illegible]